

Work Order ID 122428

122428 RA

Page 1

July-16-14 11:46:23 AM

Item ID: D206-642-555

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART
(Apical) Tri-Bag & OE

Start Date: 7/16/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MJS Date: 14-07-16 Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Rate Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	-----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4362-043

PC 400

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D206-642-555 CHG002

N/A MJS 1504-07

Work Order ID 122428

July-16-14 11:46:23 AM

122428

Page 2

Item ID: D206-642-555 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART
(Apical) Tri-Bag & OE
Start Date: 7/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/16/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
110									
Skidtubes	Memo	0.00							
Skidtubes	1- Fabricate as per Dwg: D4362-043.								
	2- Remove fwd indexing ridge as per dwg and prepare for welding								
	3 -Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod. A/RAluminum Rod <u>M125127</u>								
	4- Grind welds flush to Fwd cap on top surface only.								
	5- Cut AFT end of tube at 170.9" as per dwg and deburr end.								
	6- Drill Aft cap pilot hole using DT8025								
	7 -Cleco DT8025 in position and install pilot hole drill Jig DT8891. Drill 3/16" pilot holes as per Dwg								
	8- Remove inner indexing ridge on aft end of skidtube as per Dwg scribe batch#								
	9- Open aft end cap holes to Ø0.208" as per Dwg. Deburr aft end.								

July-16-14 11:46:23 AM

Page 3

[illegible]

Work Order ID 122428

122428

Page 4

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART (Apical) Tri-Bag & OE
 Start Date: 7/16/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/16/14 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg								
	2-deburr crossbolt spacer holes as per Dwg and blow out chips from inside the tube								
	3-Bond web in place as per Dwg & OSI 015.								
	A/RSikaflex-291 <u>129457</u>								
	Sikaflex expire date: <u>14-11-20</u>								
	Start: <u>14-9-22</u> Time: <u>3:40</u>								
	Finish: <u>14-9-22</u> Time: <u>3:55</u>								
	(Adhere for 12 hours)								

DP 14-9-22

> DP 14-9-22

14-9-22 *AL*

Work Order ID 122428

122428

Page 5

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART Stop *NS2*
 (Apical) Tri-Bag & OE
 Start Date: 7/16/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
150	QC5- Inspect part completeness to step on W/O	0.00								
150										
QC	Memo	0.00				1	0	140923		
Quality Control										

DAS
18
8-89

Work Order ID 122428

122428

Page 6

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART (Apical) Tri-Bag & OE
 Start Date: 7/16/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. AFT as per dwg. Install drop pins in crossbolt spacer holes to maintain web position.

2-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD
 END OF TUBE
 DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
 REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

3- Countersink crossbolt spacer holes as per Dwg

4- prepare for welding

5-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg
 Remember to back drill each hole before welding the other side. Use aluminum rod
 A/RAluminum Rod M125127

6-Grind cross bolt welds flush as per Dwg. DEL 14-9-26

7-Counterbore 5/16" x 0.750" deep as per Dwg.

14-9-23
BE14-09-25
14-10-1

Work Order ID 122428

122428

Page 7

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART (Apical) Tri-Bag & OE
 Start Date: 7/16/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 DAS 16 9-89 14/10/06							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 16 9-89 14/10/06							
190 *190* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00							1 x of [Signature] 14/10/08

Work Order ID 122428

122428

Page 8

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept *N900040100* Setup Start *NS1*

Revision ID:

Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART (Apical) Tri-Bag & OE Stop *NS2*

Start Date: 7/16/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 7/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							DAS 41 9-89
200									14-10-10
SprayPaint	Memo	0.00							
Spray Painting	Make sure Nut Plate Thread is protected using paint screw,								
	1- PRIME AS PER DWG AND QSI 005 4.2								
	PRIMER PRC DESOTO 515X349 BATCH: 129568								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2								
	PAINT BATCH: 130308								
210	QC14- Inspect Spray Paint	0.00							
210									
QC	Memo	0.00							
Quality Control									

DAS
15
9-89

Work Order ID 122428

122428

Page 9

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART (Apical) Tri-Bag & OE
Start Date: 7/16/14 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 7/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HAND FINISHING RESOURCE #1	0.00				14	6	11	15102/17
220	HandFinish								
Hand Finishing	14.07.14 Memo Apply wing WALK as per Dwg. Note #2 1-Install Nut Plate as per Dwg. Apply LPS-PROCYON to Nut Plate and rivets. A/RN/ALPS-PROCYON <u>122400</u> 2-Install inserts as per Dwg. Use a drop of Sikaflex inside insert holes a A/RSikaflex-291 <u>131120</u> Sikaflex expire date: <u>12108</u>								P70
230	QC5- Inspect part completeness to step on W/O	0.00				16	15-2-17		333
230	QC								
Quality Control	X Memo Inspect Nut Plate & Inserts	0.00							

Date: 15/05/05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

[Signature]

Date:

15/04/30

Work Order update only

☐

Work Order: <u>122428</u> Part No. <u>D206-642-SSS</u> NCR No. <u>15-4844</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☒</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling	1502/11	160	①	During assembly of Skid operator find missing holes for aft wear pad		Rework • locate wear pad with existing drill jig and transfer drill	<i>[Signature]</i> 15-2-10AS 15 9-89	DAS 9-89	
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Location

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☒ Other <i>w/o Route not correct</i>	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled
--	--	---	--	--

Work Order ID 122428

122428

Page 10

July-16-14 11:46:23 AM

Item ID: D206-642-555

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART
(Apical) Tri-Bag & OE

Start Date: 7/16/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 7/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	HandFinishing	0.00							
240	HandFinish	0.00							
Hand Finishing	Memo								
	1-Install wearpads as per Dwg.								
	2-Install ring as per Dwg A/RSikaflex-291 <u>11/3/12</u> Sikaflex expire date: <u>15/08</u>								
	3-Inspect for foreign objects as per QSI 024								
	4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/RSikaflex-291 <u>11/3/12</u> Sikaflex expire date: <u>15/08</u>								
	5- Apply wing walk as per dwg, see note 2.								
	A/R wing walk batch: <u>11130936</u>								
250	QC5- Inspect part completeness to step on W/O	0.00							
250	QC	0.00							
Quality Control	Memo								

DAS

38

9-89

FEB 19 2015

Work Order ID 122428

122428

Page 11

July-16-14 11:46:23 AM

Item ID: D206-642-555 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH, DART (Apical) Tri-Bag & OE
 Start Date: 7/16/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 7/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Packaging	0.00							
260									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-555								
	Location: _____								
	PPP rev: _____								
270	QC21- Final Inspection - Work Order Release	0.00							
270									
QC	Memo	0.00							
Quality Control									

PP 131 227

APR 02 2015

3-25-15

MLJ 1504-07

MS 4-6

Picklist Print

July-16-14 11:46:27 AM

Page 1

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.03.27 new issue DD verf:JLM
13.09.05 CHG002/ECN 13-634 DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-1-190		Manufactured	No				Each	85.0000					
-------------	--	--------------	----	--	--	--	------	---------	--	--	--	--	--

D2600-1-190

Extrusion Round 3" 206

Location	Loc Qty	Loc Code
----------	---------	----------

HALL	85	
108169	84	
69622	1	

D2646		Manufactured	No				Each	42.0000					
-------	--	--------------	----	--	--	--	------	---------	--	--	--	--	--

D2646

Aft Cap

Location	Loc Qty	Loc Code
----------	---------	----------

FG	4	
85848	2	
90495	2	
FP001	38	
103306	2	
107857	1	
110816	11	
113830	18	
114495	6	

B127921

X1

D3274-041-Bent

B120287

Qty!

BE 4-07-21

Picklist Print

July-16-14 11:46:27 AM

Page 2

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

D2649

Manufactured No

Each

356.0000

Start Qty: 1.00

12

Required Qty: 1.00

D2649

Cross Bolt Spacer

**

BE14-09-24

Location

Loc Qty

Loc Code

LG

234

112728

6

113811

19

120508

209

LG001

122

107906

3

108633

113

90497

6

12

D3275-1

Manufactured No

Each

297.0000

39

D3275-1

Crossbolt Spacer

**

BE14-09-24

Location

Loc Qty

Loc Code

LG

235

113246

1

114877

110

121868

60

121974

64

LG001

62

113851

62

9

30

D3282-041

Manufactured No

Each

1.0000

1

D3282-041

Float Web (206L/407)

**

Location

Loc Qty

Loc Code

LG

1

113149

1

119524

1

14-9-22

July-16-14 11:46:28 AM

Shop Packet Print

Page 2

Picklist Print

July-16-14 11:46:28 AM

Page 3

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

D3285-1

Manufactured No

Each

11.0000

Start Qty: 1.00

Required Qty: 1.00

1

D3285-1

Cap

**

BE14-07-21

Location

Loc Qty

Loc Code

LG001

11

(108052)

11

Each

145.0000

24

**

all 15/02/13

D3411-3

Manufactured No

D3411-3

Washer

Location

Loc Qty

Loc Code

ST037

145

B127625

x24

108699

58

112501

55

112735

32

Each

48.0000

1

**

all 15/02/13

D3413-1

Manufactured No

D3413-1

O-Ring

Location

Loc Qty

Loc Code

ST525

48

B121783

x1

106048

1

110715

15

112309

8

114489

3

114528

1

116664

1

120218

19

Each

28.0000

1

**

all 15/02/13

D3415-041

Manufactured No

D3415-041

Nut Plate

Location

Loc Qty

Loc Code

ST037

28

113764

28

x1

July-16-14 11:46:28 AM

Shop Packet Print

Page 3

Picklist Print

Page 4

July-16-14 11:46:28 AM

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

D3873-3

Manufactured No

Each

94.0000

Start Qty: 1.00

Required Qty: 1.00

20

D3873-3

Bushing

**

ll 15/02/12

Location

Loc Qty

Loc Code

ST063

94

112239

4

113030

40

121422

20

88201

30

x11

x9

D3904-1

Manufactured No

Each

316.0000

**

8

D3904-1

Washer

ll 15/03/13

Location

Loc Qty

Loc Code

ST064

316

113662

200

118903

116

B125626

x9

D4368-041

Manufactured No

Each

0.0000

**

1

D4368-041

Fwd Wearplate Assembly

B128708 (x1) ll 15/02/13

D4368-043

Manufactured No

Each

0.0000

**

1

D4368-043

Aft Wearplate Assembly

B128769 (x1) ll 15/02/13

D4383-1

Manufactured No

Each

0.0000

**

1

D4383-1

Wearpad

B125130 (x1) ll 15/02/13

D4383-3

Manufactured No

Each

0.0000

**

1

D4383-3

Wearpad

B125277 (x1) ll 15/02/13

July-16-14 11:46:28 AM

Shop Packet Print

Page 4

Picklist Print

July-16-14 11:46:28 AM

Page 5

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

ALS7-1032-130

AELS8-1032-130 Purchased No

Each

8,710.000

Start Qty: 1.00

Required Qty: 1.00

8

AI S7-1032-130 *ALS4-1032-130

**

ll 15/02/13

Rivnut

Location

Loc Qty

Loc Code

FG

100

121444

100

ST553

8610

M128649

8610

Each

151.0000

**

x 8
2

ll 15/02/13

AN3C36A

Purchased

No

AN3C36A

Bolt

Location

Loc Qty

Loc Code

FG

25

101261

4

122204

11

124827

10

ST347

126

m127769

1

m128398

21

m128773

75

m129432

29

11129907

x2

July-16-14 11:46:28 AM

Shop Packet Print

Page 5

Picklist Print

July-16-14 11:46:28 AM

Page 6

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

AN3C37A

Purchased

No

Each

524.0000

Start Qty: 1.00

2

Required Qty: 1.00

AN3C37A

BOLT

**

all 15/02/13

Location

Loc Qty

Loc Code

ST347

264

M124131

1

M127823

8

M129650

200

M129687

55

x2

ST353

10

M124131

1

M127823

9

ST514

250

M128491

50

M128773

200

AN3C40A

Purchased

No

Each

45.0000

**

6

all 15/02/13

AN3C40A

Bolt

Location

Loc Qty

Loc Code

FG

5

11442

5

ST353

40

114442

1

M125958

1

M126176

8

M128491

20

M128994

10

x4

x2

July-16-14 11:46:29 AM

Shop Packet Print

Page 6

Picklist Print

July-16-14 11:46:29 AM

Page 7

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

AN3C4A

Purchased

No

Each

Start Qty: 1.00
3,293.000

Required Qty: 1.00
10

AN3C4A

Bolt

all 12/02/17

Location

Loc Qty

Loc Code

FG

20

122814

20

M130716

x10

ST350

3273

124221

12

125388

3

M127410

1

M127832

62

M128606

32

M128634

8

M128739

4

M128879

651

M129520

2500

AN4C5A

Purchased

No

Each

81.0000

1

AN4C5A

Bolt

all 12/02/17

Location

Loc Qty

Loc Code

ST355

81

122599

8

123265

1

M127410

22

M128403

50

x1

Picklist Print

July-16-14 11:46:29 AM

Page 8

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

CCR264SS3-3

Purchased

No

Each

461.0000

Start Qty: 1.00

2

Required Qty: 1.00

CCR264SS3-3

Cherry Rivet

all 15/02/17

Location

Loc Qty

Loc Code

ST321

461

113973

26

m126282

47

m126333

88

m128636

100

m128818

200

x2

CR3212-4-03

Purchased

No

Each

1,043.000

2

CR3212-4-03

Cherry Rivet

all 15/02/17

Location

Loc Qty

Loc Code

ST321

1043

114889

1

119017

700

m114859

100

m123265

242

x2

MS21043-3

Purchased

No

Each

703.0000

10

MS21043-3

Nut

all 15/02/17

Location

Loc Qty

Loc Code

FG

80

103691

80

ST306

623

m128398

90

m129472

33

m129521

500

11/13/06 FS

x10

Picklist Print

July-16-14 11:46:29 AM

Page 9

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

NAS1149C0332R

Purchased

No

Each

5,726.000

Start Qty: 1.00

8

Required Qty: 1.00

NAS1149C0332R

WASHER

all 15/02/14

Location

Loc Qty

Loc Code

CA

83

m129682

83

1131340

18

ST278

5643

122063

41

125654

765

m126319

61

m127306

2500

m127410

543

m127831

26

m128591

84

m129390

600

m129499

1023

NAS1149C0363R

Purchased

No

Each

964.0000

2

NAS1149C0363R

Washer

all 15/02/14

Location

Loc Qty

Loc Code

ST278

964

114742

550

122441

15

m128591

399

12

Picklist Print

Page 10

July-16-14 11:46:29 AM

Work Order ID: 122428

122428

Parent Item: D206-642-555

D206-642-555

Parent Item Name: Replacement Skidtube, High Gear, Run-on Landing Wearplates Fits LH or RH,
DART (Apical) Tri-Bag & OE

Start Date: 7/16/14

Required Date: 7/16/14

NAS1149C0463R

Purchased

No

Each

710.0000

Start Qty: 1.00

1

Required Qty: 1.00

NAS1149C0463R

Washer

all 15/02/17

Location

Loc Qty

Loc Code

ST278

710

119097

1

123248

1

123355

55

m127306

153

m128401

500

X1

NAS1515H3L

Purchased

No

Each

411.0000

2

***NAS1515H3L ***

Washer

all 15/02/17

Location

Loc Qty

Loc Code

FG

40

102472

40

ST273

371

m127831

148

m128976

223

all 13 07 20

X2

July-16-14 11:46:30 AM

Shop Packet Print

Page 10

Qty -041	Qty -043	Part Number	Description
X		D4362-041	SKIDTUBE ASSEMBLY
	X	D4362-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
14	39	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
24	24	D3411-3	WASHER
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
20	20	D3873-3	BUSHING
8	8	D3904-1	WASHER
1	1	D4368-041	FWD WEARPLATE ASSY
1	1	D4368-043	AFT WEARPLATE ASSY
1	1	D4383-1	WEARPAD
1	1	D4383-3	WEARPAD
8	8	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
2	2	AN3C36A	BOLT
2	2	AN3C37A	BOLT
6	6	AN3C40A	BOLT
10	10	AN3C4A	BOLT
1	1	AN4C5A	BOLT
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
10	10	MS21043-3	NUT
8	8	NAS1149C0332R	WASHER (OR AN960C10L)
2	2	NAS1149C0363R	WASHER (OR AN980C10)
1	1	NAS1149C0463R	WASHER (OR AN980C416)
2	2	NAS1515H3L	WASHER

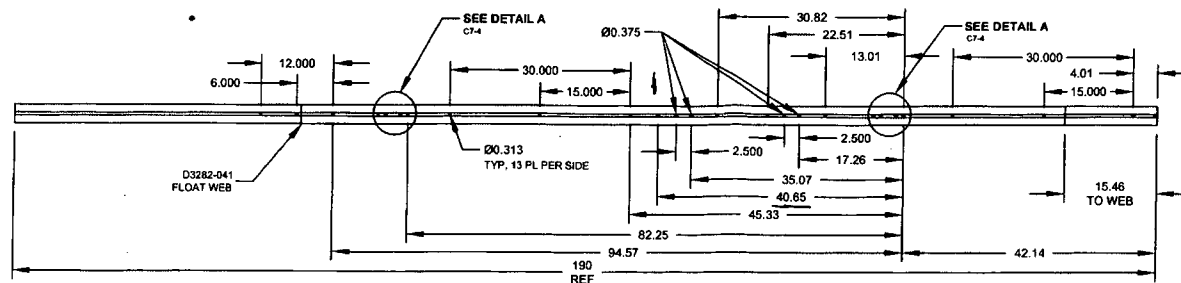
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB
- PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
- BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4362-041 = 54.0 LBS
D4362-043 = 54.3 LBS
- 8) WELD PER DART QSI 004
- 9) ALL HOLES DRILLED ON CENTERLINES.
- 10) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND D3282-041 FLOAT WEB INTO D4362-041/-043 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 12) DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT4362-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX-241/291.
- 13) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN OFF EXCESS GREASE WITH WASH 'N WIPE DEGREASER.

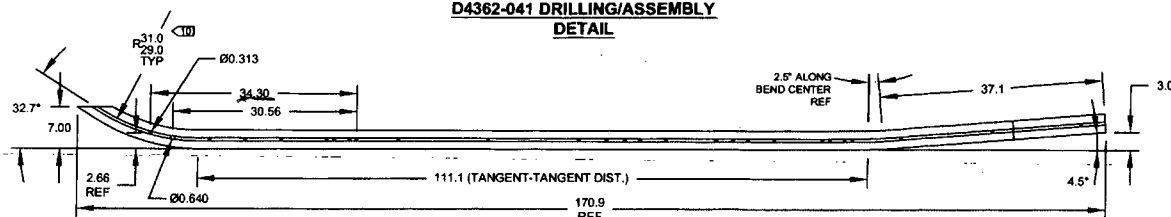
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122285 MJS
14-07-15

RELEASED
2014-05-26

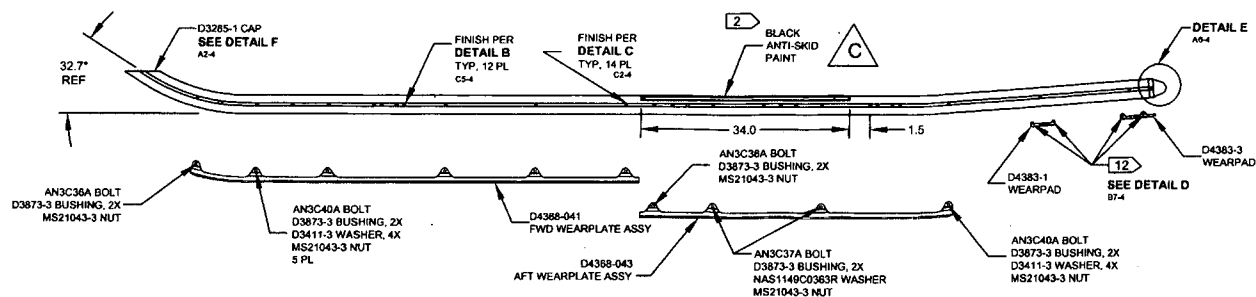
C	REVISE NOTE 2: ADD ANTI-SKID PAINT	DB	14.04.15
B	REVISE NOTE 2: FINISH NOW PRIME/PAINT WAS POWDERCOAT, REF. PAR13-256	DW	13.05.17
A	NEW ISSUE	SC	11.05.05
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DB		
CHECKED	DW	DRAWING NO.	REV. C
MFG. APPR.	DW	D4362	SHEET 1 OF 4
APPROVED	DW	TITLE	SCALE
DE APPR.	DW	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	14.04.15	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	



**D4362-041 DRILLING/ASSEMBLY
DETAIL**



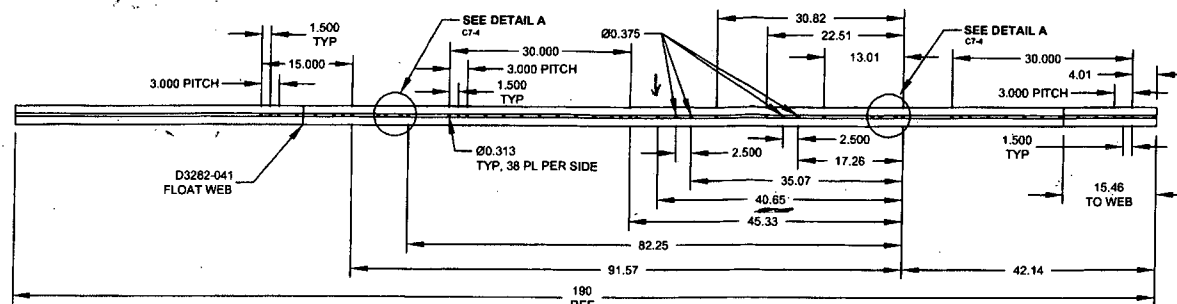
D4362-041 BEND/DRILLING DETAIL



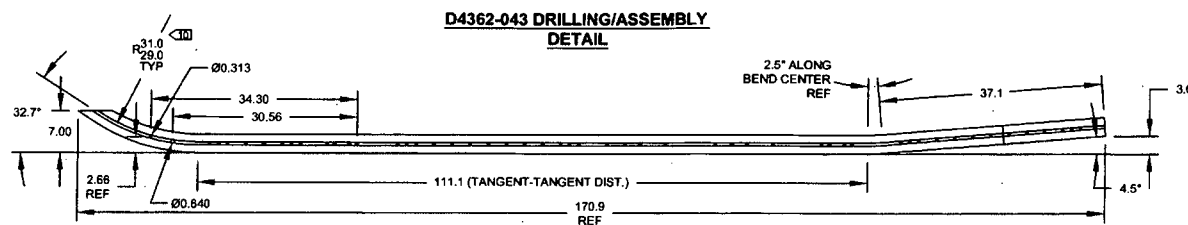
D4362-041 SKIDTUBE ASSEMBLY

RELEASED
2014-05-26

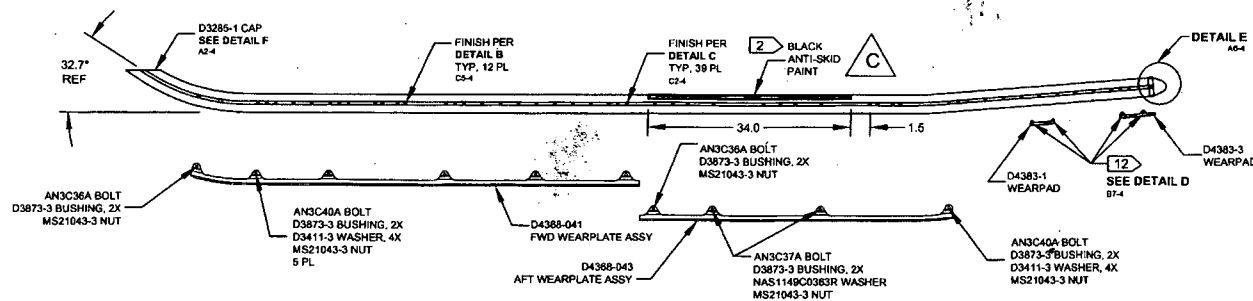
DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	DB	KENT, WA	
CHECKED	A.P.	DRAWING NO. D4362	REV. C
MFG. APPR.			SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	14.04.15	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**D4362-043 DRILLING/ASSEMBLY
DETAIL**



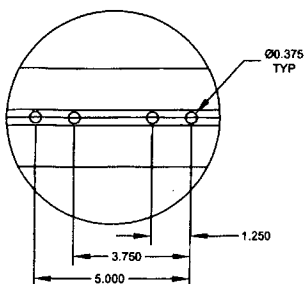
D4362-043 BEND/DRILLING DETAIL



D4362-043 SKIDTUBE ASSEMBLY

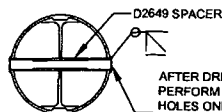
RELEASED
2014-05-26

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	DB	KENT, WA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>A.P.</i>	D4362	SHEET 3 OF 4
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	14.04.15	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



DETAIL A

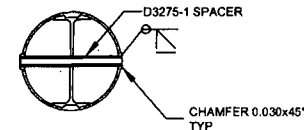
D3-2
D5-2
D3-3
D5-3



DETAIL B
FOR Ø0.375 HOLES ONLY

B5-2
B5-3

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

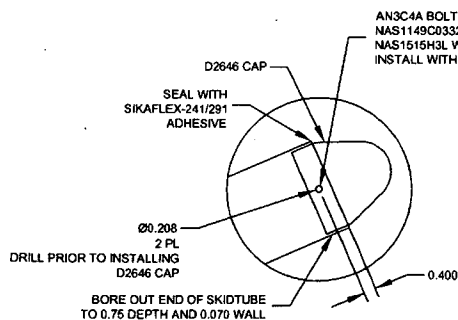


DETAIL C
FOR Ø0.313 HOLES ONLY
B4-2
B4-3



DETAIL D
A2-2
A2-3

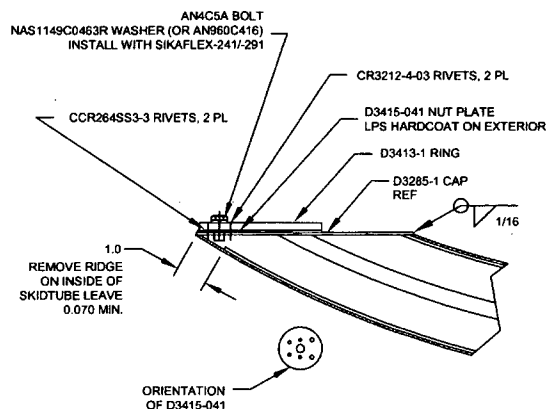
ALS7-1032-130 INSERT
AN3C4A BOLT
NAS1149C0332R WASHER (OR AN960C10L)
8 PL
D4383-1/3 WEARPAD
REF



DETAIL E

B2-2
B2-3

AN3C4A BOLT
NAS1149C0332R WASHER (OR AN960C10L)
NAS1515H3L WASHER, 2X
INSTALL WITH SIKAFLEX-241/291



DETAIL F
END FINISHING DETAIL
B6-2
B6-3

DETAIL F NOTES:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

RELEASED
2014-05-26

DESIGN	SC	DART AEROSPACE USA, INC	
DRAWN	DB	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.		D4362	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		206L/407 SKIDTUBE ASSEMBLIES	NTS
DATE	14.04.15	COPYRIGHT © 2011 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	